Work Orde February-14-13				*970	122*							Page 1
Item ID: Revision ID:	D3833-5			Accept	*N900	040	100)*	Setup		*N:	S1*
Item Name:	Mesh (Lid En	d)								Stop	*N:	S2*
Start Date:	2/18/13	Start Qty: 4.00	*4*		Cust Item I	D:						
Required Date: Reference:	2/28/13	Req'd Qty: 4.00	*4*		Customer:		1					
Approvals:	Process Pla	an: MCJ	Date: 13-02	-15 Tooling:	Da	ate:		. 1	Run	Start Stop	17	R1*
	QC:		Date:	SPC (Y/N):	D:	ate:		٠		эгор	*N	R2*
Sequence ID/ Work Center II	D .	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr										
D3833	В	:										
100				0.00								
100		FLOW WATER JET Memo		0.00				4		0		Jm13-3-19
FLOW CNC Waterj	et	1-Cut as per Dwg Rev:_	Dwg D3833 B	0.00								
		Prog Rev: 2-Deburr if	necessary									
110		QC2- Inspect parts off m	nachine FAI/FAIB	0.00								
110								1	_	_		Tu. 12 2-19

0.00

Memo

Quality Control

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Engineering Crosstube Water Jet Rework Skid-tube Quality Small Fab Prod. Eng. Coor. Machining Part No. Scrap Other Rec/Store/Packaging Thermoforming Finishing Use-as-is Supplier Work Order Update Large Fab Composite NCR No. Action Sign & Description of work order update Initial Root Verification QC Inspector Chief Eng Description Date Date Step Qty or Non-conformance Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY** General **Landing Gear** Pressure/Forced Ovalized Grain Bend Bending Temperature/Cure Over/Under tolerance BOM/Route Hardware Centre Not Concentric to O/S Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Maintenance Part Moved Cuffs Contamination Mislabeled Positioned Wrong Countersink Heat Treat Other Power Loss/Surge Cut Too Short Misread Inspection Strip in Tube

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 97022 Page 2 February-14-13 1:10:04 PM Item ID: D3833-5 Accept Setup Start *N900040100* **Revision ID:** Mesh (Lid End) Item Name: Start Qty: 4.00 **Start Date:** 2/18/13 **Cust Item ID: Req'd Qty:** 4.00 Required Date: 2/28/13 **Customer:** Reference: Run Start Date:_____ **Tooling:** Process Plan: **Approvals:** Date: Stop SPC (Y/N): Date: ____ Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Number Stamp **Work Center ID** Code Qty Qty **Description Run Hours** 0.00 120 QC8- Inspect parts - second check *120* QC 0.00 Memo Quality Control Identify as per dwg & Stock Location: WA 7 0.00 130 (p(13.3.20 *120* 0.00 Packaging Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 M15 13-03-70 QC 0.00 Memo

Quality Control

												DQA:	Dat	e:	
NCR: Y	'es	/ No				WORK ORDER NON-C	CON	IFORM	AANCE / UP	DATE				-	
												QA Closed:	Dat	e:	·
Work Orde						DISPOSITION				AGAINST I	DE	PARTMENT/	PROCESS		
WOIK OIU	-1.					Rework	1 I		Skid-tube	Crosstube	$\overline{}$		Water Jet	\neg	Engineering
Part f	No.					Scrap	1	ı	Machining	Small Fab		Proc	d. Eng. Coor.	\exists	Quality
	•		**			Use-as-is	1		noforming	Finishing			e/Packaging		Other
NCR I	No.					Work Order Update]		Large Fab	Composite			Supplier		
	•														
Root	-				1	ption of work order update		nitial		tion		Sign &			
Cause		Date	Step	Qty	•	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	ו	QC Inspector
Doc/Data					[
Equip/Tooling											,				
Operator		i	1				1								
Material	Ш													i	
Setup	Ш														
Other															
Process															
Supplier			i .												
Training			1												
Unapproved			<u> </u>	<u> </u>				_							
						F	AUL	T CATE	GORY						
Landi	ng (Gear				General				,	_	7	1		Ī
		Bending			L	Bend		Grain			_	Ovalized			Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	are		_	Over/Under			Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete			Part Incorred	ct		Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

February-14-13 10:45:17 AM

Work Order ID:

97022

Parent Item:

C

D3833-5

Parent Item Name:

Mesh (Lid End)

Start Date: 2/18/13

Required Date: 2/28/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 08-12-01 new issue DD verified by:EC

IPP REV:B 12.07.27 AS PER

	DWG REV.B DD	VERF:EC											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location		Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F Expanded Metal Flat SS		Purchased	No			100	sf	1,240.5763	0.1945	0.8189474			JMB3-18
				Location		Loc Qty	<u>Lo</u>	c Code					
				WA		321							
					124070	1							
					124466	320							
				WA007		919.5762637							
					117197	102.9036							

120917 50.88673 121521 0.00013372 122080 63.0699 122315 0.395 122534 160 122604 61.238 . 122884 36.5679 123448 193.31 123855 147.07 104.135 124347

124840

124840

											DQA:	Date		
NCR:	⁄es	/ No				WORK ORDER NON-	·CO	NFORM	MANCE / UPI					
											QA Closed:	Date	:	
Work Orde	n die		•			DISPOSITION	AGAINST DEPARTMENT/PROCESS							
WORK Of GR	٠. ٠				 -	Rework			Skid-tube	Crosstube		Water Jet	Engineering	
Part N	No.					Scrap	\dashv	3	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
	•••					Use-as-is	┥.		noforming	Finishing	i .	e/Packaging	Other	
NCR I	No.					Work Order Update	1	li .	Large Fab	Composite		Supplier	1 🗆	
	•			1		`				<u> </u>				
Root					Descri	ption of work order update		Initial	Act	tion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	CI	nief Eng	Desci	ription	Date	Verification	QC Inspector	
Doc/Data								!						
Equip/Tooling									·					
Operator														
Material			ļ											
Setup]						·					
Other				†										
Process	<u> </u>													
Supplier	<u> </u>						İ							
Training	_													
Unapproved	<u> </u>	<u> </u>						IT CATE	CODY		<u> </u>			
				w		General	FAU	LT CATE	GORT					
Landi	ing (1				Bend	Г	Grain			Ovalized		Pressure/Forced	
	\vdash	Bending Contro N	at Canca	ntric to C	\(\s\ \-	BOM/Route	\vdash	Hardwa	aro	<u> </u>	Over/Under	tolerance	Temperature/Cure	
	\vdash	Cracks	or conce	intric to C	"³	Broken/Damaged	\vdash	⊣	ion Incomplete	 	Part Incorre		Weld	
	\vdash	Crushed	/Crimned		-	Burrs	\vdash		tions Incomplete/	Unclear	Part Lost/Mi	<u> </u>	Wrong Stock Pulled	
	-	Cuffs	Cimpeu			Contamination	\vdash	Mainte		<u> </u>	Part Moved			
		Heat Tre	at			Countersink		Mislabe		<u> </u>	Positioned V	Vrong		
		Inspection		1 Tube	 	Cut Too Short	 	Misrea		<u> </u>	Power Loss/		Other	
		Ripples i	-		·	Drill Holes		Offset		_	<u>.</u>			

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order:	97022
Description: Mesh, Lid End	Part Number:	D3833-5
Description: Mesh, Liu Enu	r arr wamber.	D0000 0
Inspection Dwg: D3833 Rev: A P Gov		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.80	+/-0.030	3.80"	_		V	JKMUI
7.37	+/-0.030	3.60° 7.37°	_		√	

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						** .
			OA.	· ·		
	L	<u> </u>	27			

Measured by:	J-	Audited by:	•	Prototype Approval:	N/A
Date:	13-3-16	Date:	13318	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	09.05.20	New Issue	KJ 984	

D3833-3 MESH, LID END A D3833-7 MESH, LID END D3833-5 MESH, LID END UNCC: . Detay SUBMITTED TO AN ST Mer. Care D3833-1 MESH, BASE END FACE NO 97022 MLJ 13-02-15 B ADD D3833-7. REASON: PAR10-50,

NEW ISSUE мв 08.09.23 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED ·REV. B D3833 MFG, APPR. SHEET 1 OF 2 APPROVED TITLE SCALE MESH, BASKET END DE APPR. DATE 12.05.30

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH, 3/4-16F REF. DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
A\ IDENTIFICATION: N/A

3) Brean Share Euges, IVA 6) IDENTIFICATION, IVA 7) WEIGHT: D3833-1 = 0.30 lbs; D3833-3 = 0.22 lbs; D3833-5 = 0.06 lbs; D3833-7 = 0.30 lbs

